

Work Order ID 85635

85635

Page 1

June-12-12 11:35:14 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 12/06/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/12 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2750	F
-------	---

D3492	C
-------	---

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

0.00

0.00

(DAS 16 8-88) rlyb2x

for MLJ 12-7-26

85635

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N9000040100

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1

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1

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Approvals: Process Plan:

Date:

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Run Start ***NR1***

QC:

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SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

JB

12/06/28

SAD

12-07-13

JB

12/06/28

SAD 12-07-16

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Stop *NR2*

Sequence ID/
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Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: M122130 BE 12/06/28

12-Grind welds flush as per Dwg D2750 -> CF 12-7-3

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

1 *HB* 12-7-16

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

① *SAD* 12-07-16

Dart Aerospace Ltd

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M122130

exp. date: 13-3-14

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: M122130

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

12/07/17

CF 12-7-17

3 BE 20718

Dart Aerospace Ltd

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Run Start *NR1*

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control



17/04/23

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

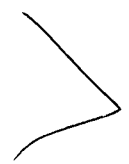
Memo

0.00

Quality Control



17/04/23



12/07/19

Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	0	1273	
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	0	12/07/23	
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:30								
	OVEN TEMPERATURE: 3200 F								
	FINISH TIME: 3:00								
210	QC3- Inspect Part Finish	0.00				1 LH	0	12/07/24	
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

M121841

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N9000040100

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Stop *NS2*

Start Date: 12/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
220	HandFinish	0.00				1LH	X	(20)	12/07/24
Hand Finishing	Memo 1- Install inserts as per Dwg D2750								
230	HandFinishing	0.00							
230	HandFinish	0.00				1LH	X	(20)	12/07/25
Hand Finishing	Memo 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: N/A 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 127,130 EXP DATE: 14/07 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 110 348 5-Coat all exposed fasteners with "LPS Procyon" batch: 114 596								

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

DAS
16
9-83

17/01/12

DAS
16
9-83

17/01/12

1K

SP
12-7-26

Ⓢ

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Date:

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QC:

Date:

SPC (Y/N):

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Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

pk v. I

12/1/27 C

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/8/11 J

~~12/07/07~~

12/27/31

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Picklist Print

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	253.0000	8	8			
D3492-1									**	8	(SP)	12/07/24	
Plug													

Location	Loc Qty	Loc Code
----------	---------	----------

FP002	238	
69531	8	
74444	2	
76235	4	
83259 ✓	224	
FP-A	15	
83098	15	

D3492-3		Manufactured	No			230	Each	163.0000	8	8			
D3492-3									**	8	(SP)	12/07/24	
Plug													

Location	Loc Qty	Loc Code
----------	---------	----------

FP-A 85461 ✓	163	
81967	5	
83099	36	
83529	122	

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Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

168.0000

8

8

NAS1611-010

O-RING

**

8

SD

12/07/24

Location

Loc Qty

Loc Code

FP001	122151✓	168
	110915	14
	117460	8
	118077	1
	118612	3
	119438	47
	121259	2
	121415	4
	121584	39
	121723	50

NAS1149D0863J

Purchased

No

250

Each

249.0000

2

2

NAS1149D0863.J

WASHER

**

SP

Location

Loc Qty

Loc Code

ST298		249
	118078	34
	119307	15
	120308	100
	121556	100

2x

D2744

Manufactured

No

110

Each

32.0000

1

1

D2744

Cap

**

OK 12/06/28

Location

Loc Qty

Loc Code

LG002		32
	62715	1
	83412	31

1

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Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

25.0000

1

1

D2600-3-BFNT

Extrusion Bent

**

Location

Loc Qty

Loc Code

LG

66875

25

73253

7

75021

1

75022

1

75023

1

81330

4

83305

1

83442

9

D2743

Manufactured No

160

Each

272.0000

8

8

D2743

Crossbolt Spacer

**

Location

Loc Qty

Loc Code

LG

81965

198

83262

55

LG001

67766

143

68251

74

73403

4

74445

3

79517

64

1

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:19 AM

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

12.0000

1 1

D2739

350 I Beam

CF 12-7-17

Location

Loc Qty

Loc Code

LG

12

72155

1

81508

1

83447

3

83448

5

83548

2

D3490-3

Manufactured No

160

Each

42.0000

4 4

D3490-3

Cross Bolt Spacer

BE 12-07-18
885420 *4

Location

Loc Qty

Loc Code

LG001

42

83313

42

D3490-1

Manufactured No

160

Each

33.0000

4 4

D3490-1

Cross Bolt Spacer

BE 12-07-18
885419 *4

Location

Loc Qty

Loc Code

LG

2

81976

2

LG001

31

62450

2

74875

4

77042

3

83269

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

683.0000

38

38

AI S4-1032-225

Insert

**

38

DP

12/07/24

Location	Loc Qty	Loc Code
ST281 122290 ✓	660	
108696	146	
110768	62	
118386	55	
118966	68	
121269	329	
ST282	23	
120410	10	
120451	13	

D3793-3

Manufactured

No

230

Each

28.0000

1

1

D3793-3

Wearshoe

**

1

DP

12/07/24

Location	Loc Qty	Loc Code
FP001	28	
83394	16	
83901 ✓	12	

AN8C35A

Purchased

No

230

Each

66.0000

1

1

AN8C.35A

BOLT

**

1

DP

12/07/24

Location	Loc Qty	Loc Code
FP002	65	
115960	1	
118286	14	
121275 ✓	50	
ST346	1	
114442	0	
115188	0	
115960	1	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85635

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

85635

D350-636-011

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

28.0000

1

1

D3793-1

Wearshoe

**

1

DP

12/07/24

Location

Loc Qty

Loc Code

FP001

28

82171

2

83393 ✓

13

83903

13

D3488-041

Manufactured No

230

Each

9.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

1

DP

12/07/24



Location

Loc Qty

Loc Code

FP002

9

61689

1

82271

8

83733 ✓

D3794-3

Manufactured No

230

Each

23.0000

1

1

D3794-3

Gasket

**

1

DP

12/07/24

Location

Loc Qty

Loc Code

FP

21

83396 ✓

21

FP002

2

74530

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

78.0000

4

4

AN6C44A

BOLT

**

4

OP

12/07/24

Location

Loc Qty

Loc Code

FG

122204

2

103964

2

ST343

76

121013

11

121167

8

121440

50

121689

7

MS21083C8

Purchased

No

230

Each

77.0000

1

1

MS21083C8

NUT

**

1

OP

12/07/24

Location

Loc Qty

Loc Code

304

~~122204~~

72

121185

27

121349

45

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

D3536-25

Manufactured

No

230

Each

28.0000

1

1

D3536-25

Gasket

**

1

OP

12/07/24

Location

Loc Qty

Loc Code

FP

28

83391

12

83900

16

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:20 AM

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

331.0000

8

8

D3631-1

Washer

**

8

(20)

12/07/24

Location

Loc Qty

Loc Code

FG

316

81874

2

83588

314

ST072

15

68062

2

75548

13

D3791-1

Manufactured No

230

Each

29.0000

1

1

D3791-1

Wearplate

**

1

(20)

12/07/24

Location

Loc Qty

Loc Code

FP002

29

62239

2

83392

15

83902

12

AN960C10L

*NAS1149C0332 Purchased

No

230

Each

21.0000

38

38

***AN960C10I ***

washer

**

38

(20)

12/07/24

Location

Loc Qty

Loc Code

ST

21

107534

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

106.0000

8

8

D2745

Bushing

**

8

Ⓚ

12/02/24

Location

Loc Qty

Loc Code

FP

85416 ✓
79518

6

6

FP001

100

69529

1

76142

1

83260

98

AN3C5A

Purchased

No

230

Each

1,270.000

34

34

AN3C5A

Bolt

**

34

Ⓚ

12/07/24

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1263

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255 ✓

500

121444

150

121708

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

19.0000

3

3

D3537-1

Wearpad

**

3

OP

12/07/24

Location

Loc Qty

Loc Code

FP002

85457✓

19

81362

6

83254

1

83255

3

84091

9

NAS1149C0832R

Purchased

No

230

Each

256.0000

1

1

NAS1149C0832R

WASHER

**

1

OP

12/07/24

Location

Loc Qty

Loc Code

ST297

256

114915✓

256

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

413.0000

4

4

AN3C6A

BOLT

**

4

DP

12/07/24

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

412

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

150

121682 ✓

170

NAS1611-013

Purchased

No

230

Each

341.0000

8

8

NAS1611-013

O-RING

**

8

DP

12/07/24

Location

Loc Qty

Loc Code

FP001

341

116582

5

117291

2

117887

53

119623

36

121584

15

121825 ✓

188

121826

42

June-12-12 11:35:20 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

34.0000

1

1

D3535-25

Wearshoe

**

7

DP

12/07/24

Location

Loc Qty

Loc Code

FP001

34

62233

1

81357

1

82156

2

83387

17

83899 ✓

13

D3794-1

Manufactured No

230

Each

26.0000

1

1

D3794-1

Gasket

**

1

DP

12/07/24

Location

Loc Qty

Loc Code

FP

6

82167

6

FP002

20

83395 ✓

20

MS21043-6

Purchased No

230

Each

610.0000

4

4

MS21043-6

NUT

**

4

DP

12/07/24

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

590

117887

2

118384 ✓

88

120308

500

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250 Each

125.0000 2

D3493-1

Washer

**

BS SP

Location

Loc Qty

Loc Code

ST050

125

77573

1

82023

24

83097

100

MS21083C8

Purchased No

250 Each

77.0000 2

MS21083C8

NUT

**

2x
m122141 SP

Location

Loc Qty

Loc Code

304

72

121185

27

121349

45

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

AN8C21A

Purchased No

250 Each

55.0000 2

AN8C21A

BOLT

**

SP 12-7-26

Location

Loc Qty

Loc Code

ST343

55

118758

3

121167

2

121275

50

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

138.0000

4

4

***NAS1515H3I ***

WASHER

**

4

SP

12/07/24



Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

98

118686

3

119438 ✓

1

120360

11

121243

2

121556

81

D2741

Manufactured

No

250

Each

54.0000

1

1

D2741

Blade, 350 Skidtube

**

SP

L

Location

Loc Qty

Loc Code

ST

-10

ST466

64

71856

1

79516

14

83135

39

D3532-1

Manufactured

No

250

Each

30.0000

2

2

D3532-1

Spacer

**

SP 12-7-26

Location

Loc Qty

Loc Code

ST053

30

82041

5

83319

25

2x

June-12-12 11:35:21 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. EST-635 MCT
12/26/12

RELEASED
68 07 12 12

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A5-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9139/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. FORT HADLOCK, WA	
DRAWN	RA		
CHECKED	AB	DRAWING NO.	REV. F
MFG. APPR.	AB	D2750	SHEET 1 OF 11
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DE APPR.	AB	350 SKIDTUBE ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

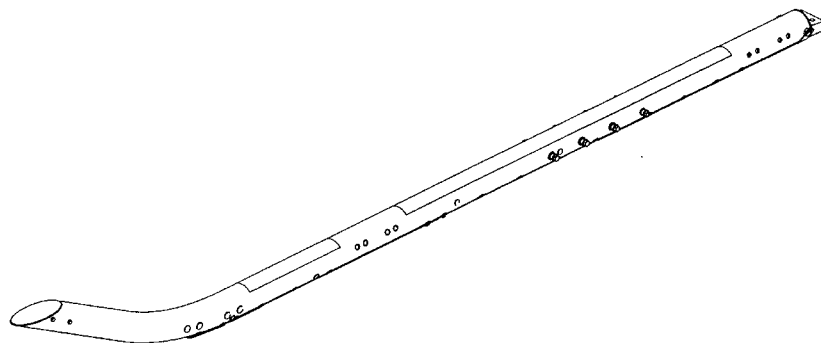
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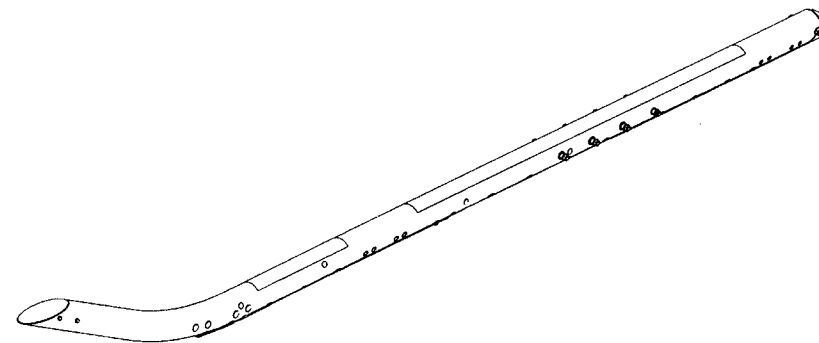
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

25635



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08-22-16

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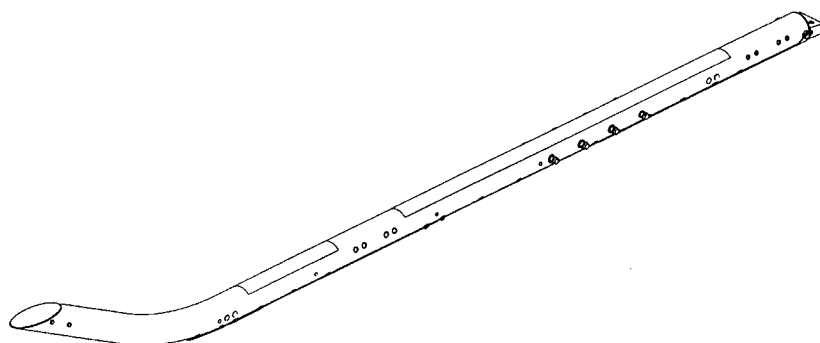
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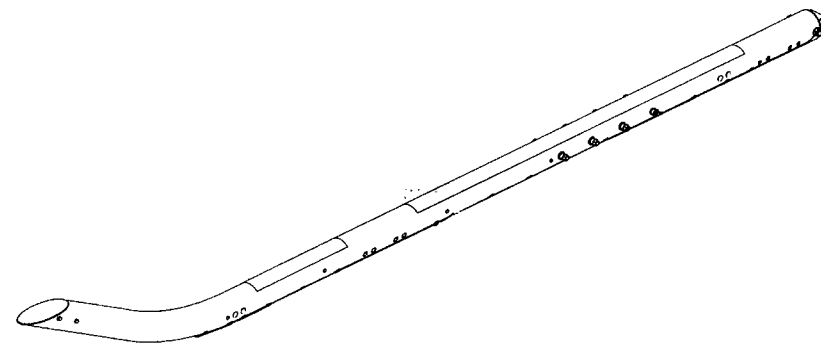
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

25635



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/11

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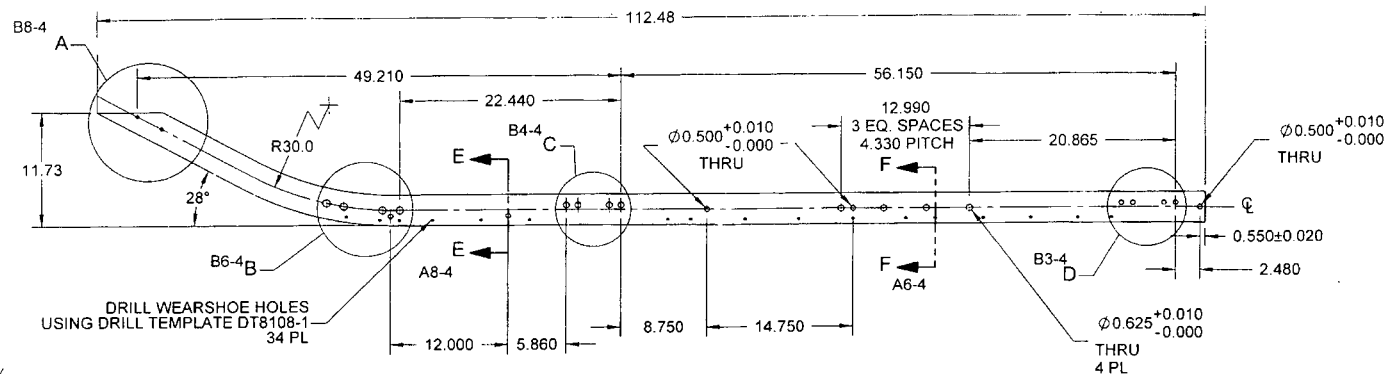
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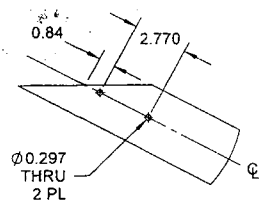
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

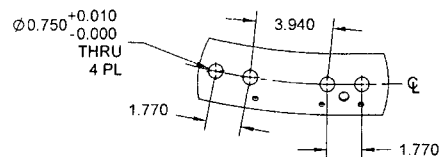
NOTE: Date & initial all entries



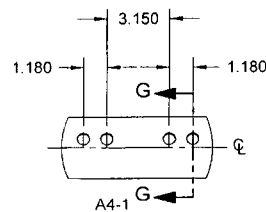
D2750-1 LH SKIDTUBE



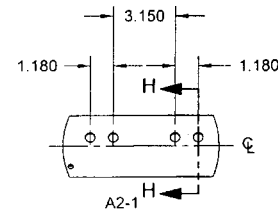
DETAIL A
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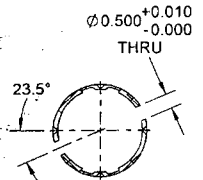
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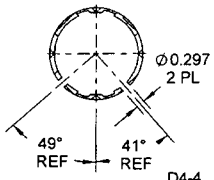
DETAIL C
SCALE 2X



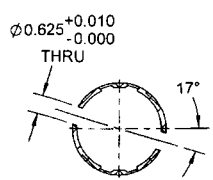
DETAIL D
SCALE 2X



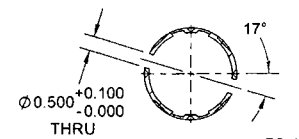
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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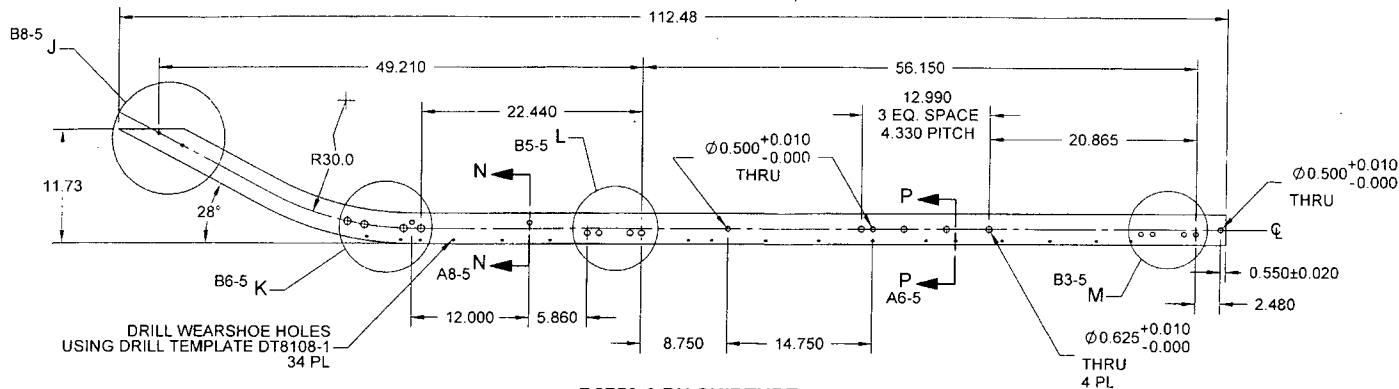
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

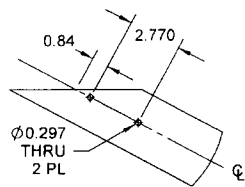
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

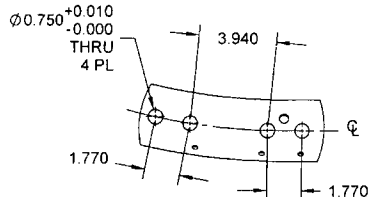
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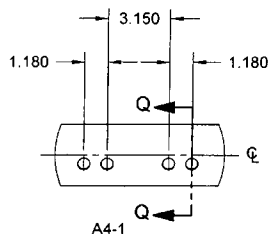
D2750-2 RH SKIDTUBE



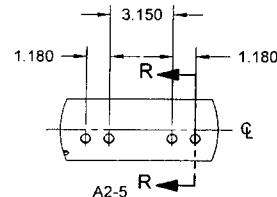
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SCALE 2X



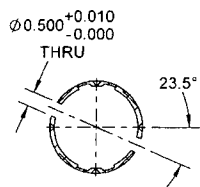
DETAIL K
SCALE 2X



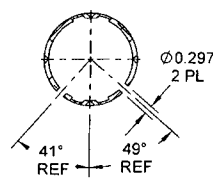
DETAIL L
SCALE 2X



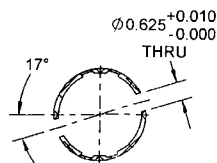
DETAIL M
SCALE 2X



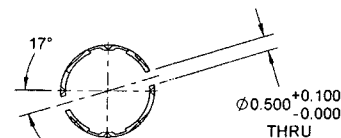
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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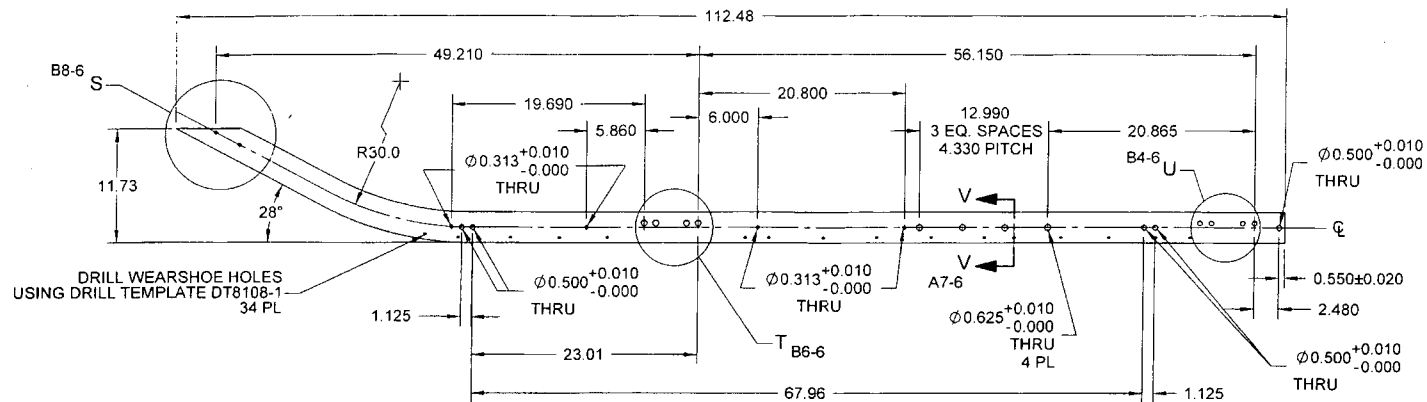
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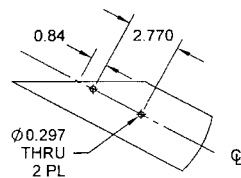
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

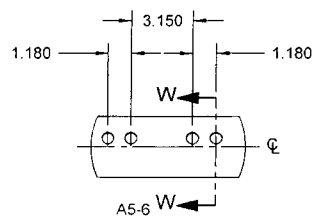
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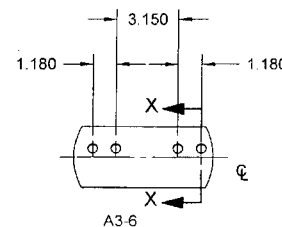
D2750-3 LH SKIDTUBE



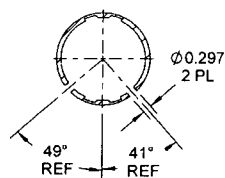
DETAIL S
SCALE 2X



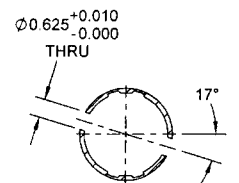
DETAIL T
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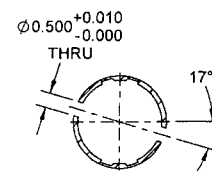
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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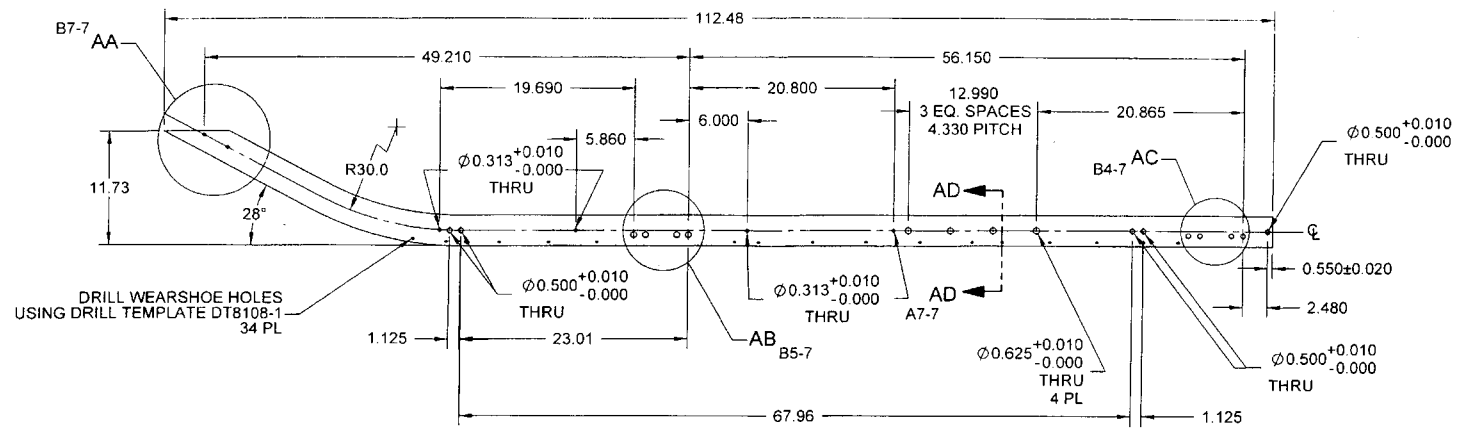
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

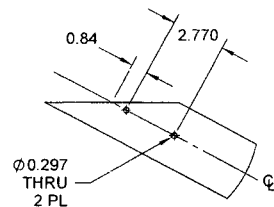
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

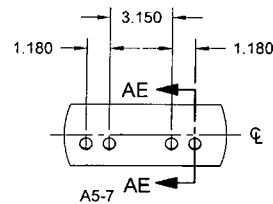
NOTE: Date & initial all entries



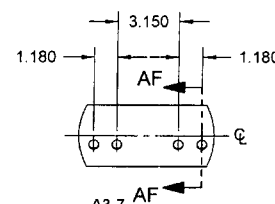
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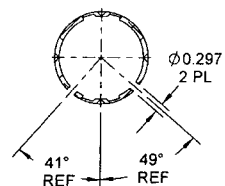
DETAIL AA
SCALE 2X
D7-7



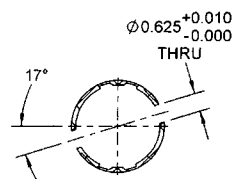
DETAIL AB
SCALE 2X
C4-7
A5-7



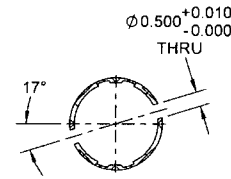
DETAIL AC
SCALE 2X
D3-7
A3-7



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7



SECTION AF-AF
SCALE 3X, 4 PL
B4-7

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08-09-22-110

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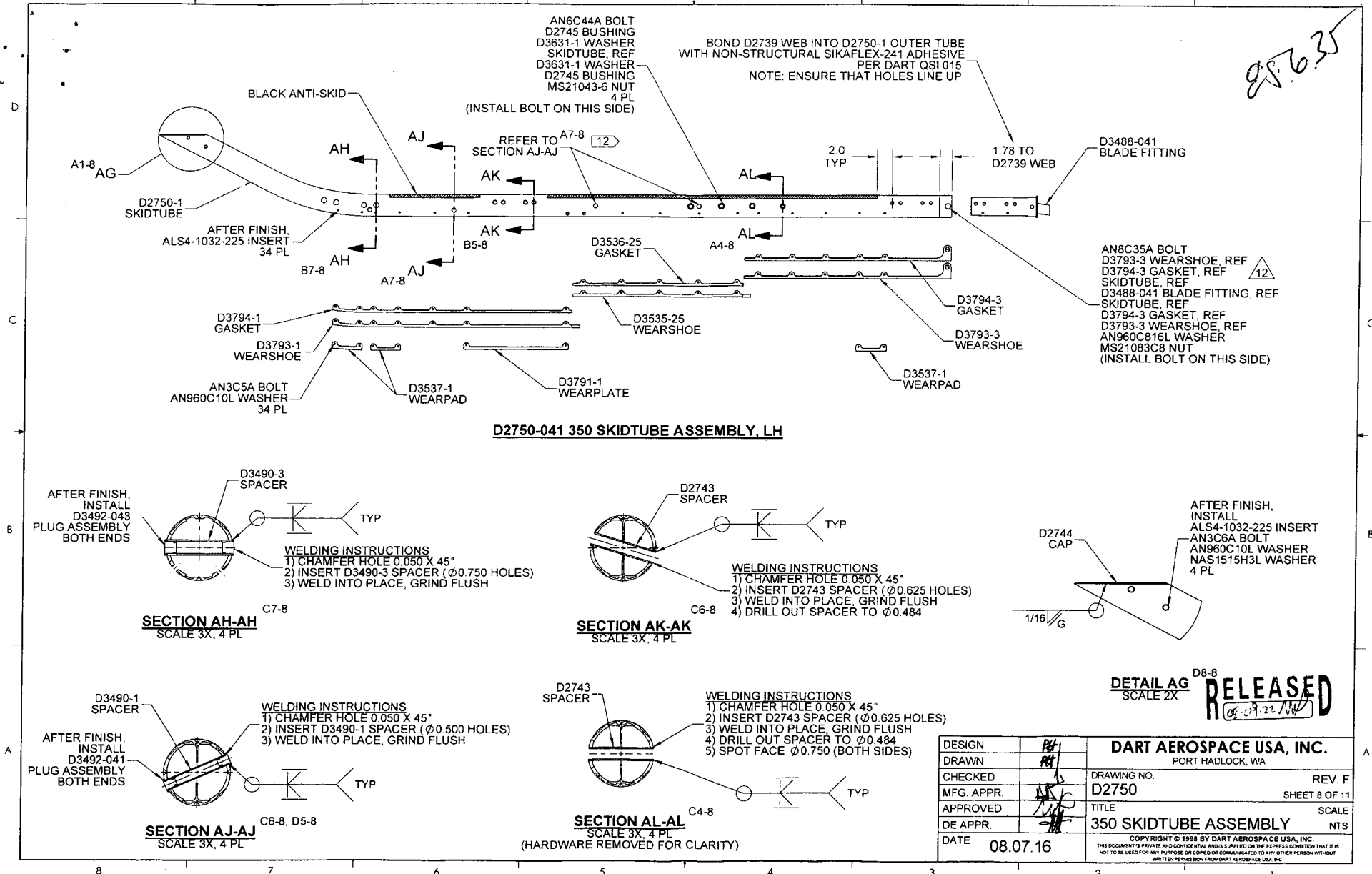
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



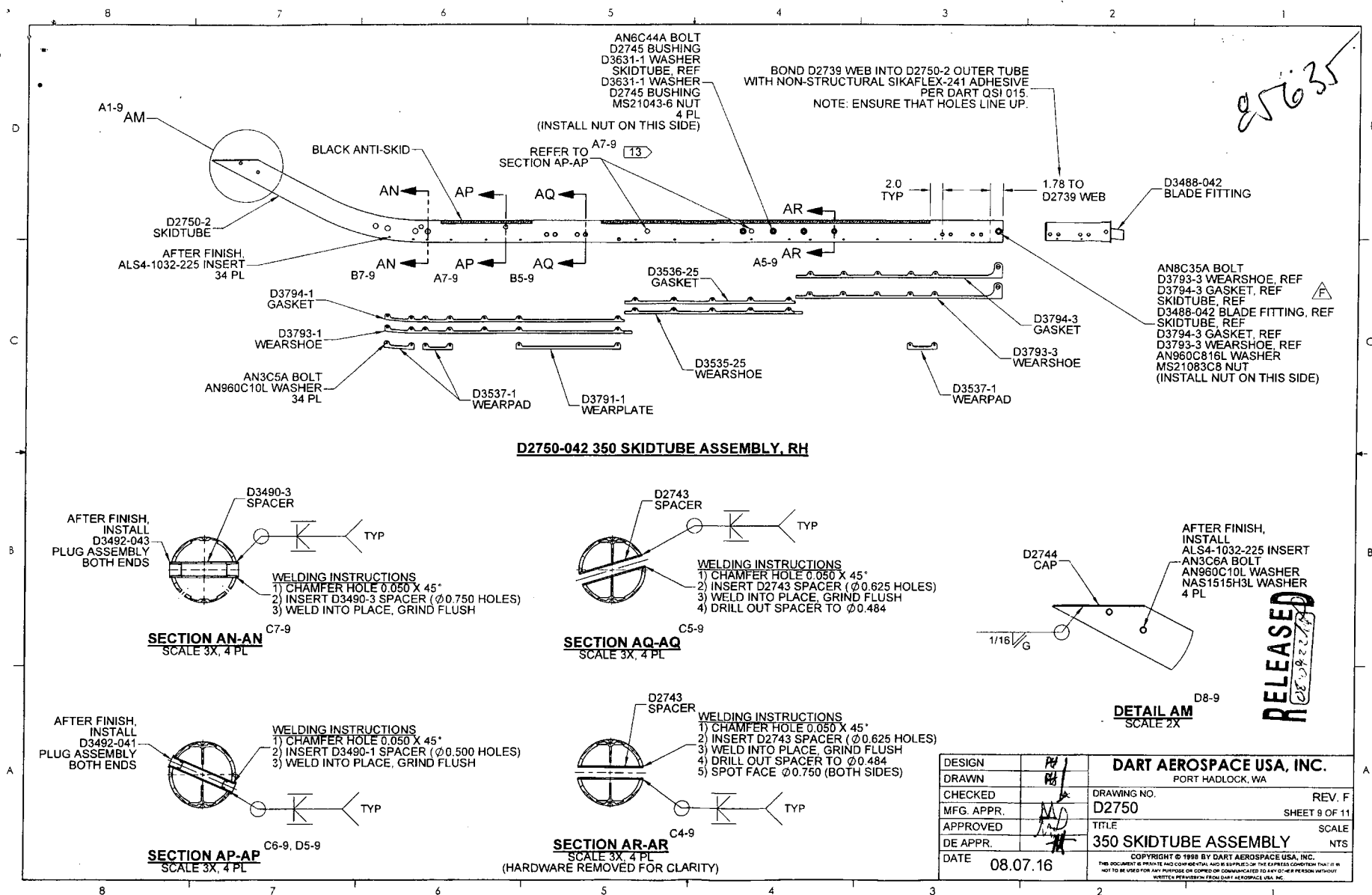
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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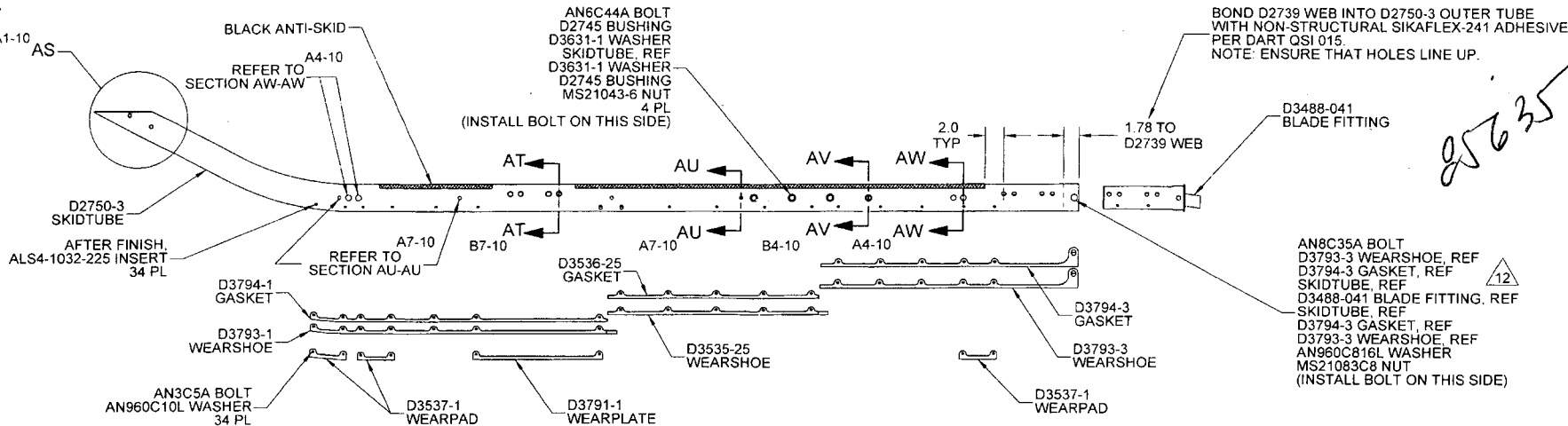
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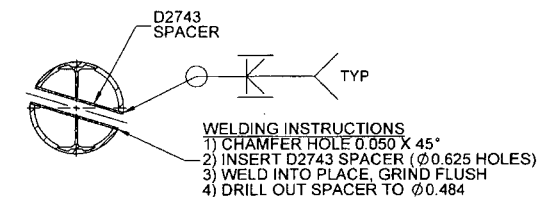
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

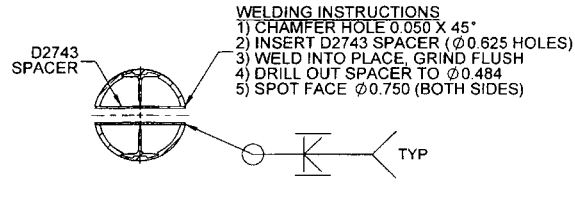
NOTE: Date & initial all entries



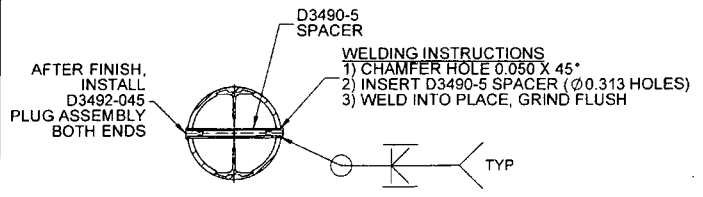
D2750-043 350 SKIDTUBE ASSEMBLY, LH



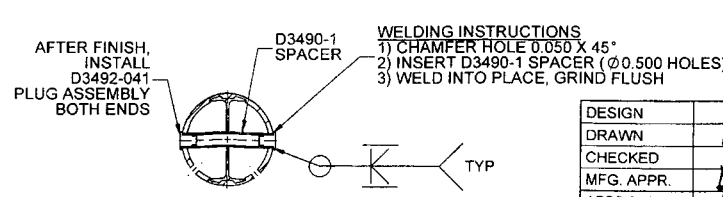
SECTION AT-AT
SCALE 3X, 4 PL



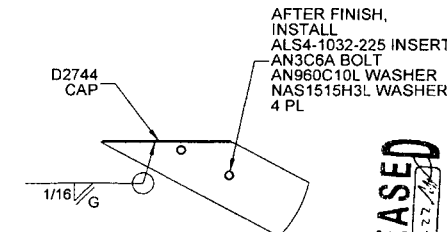
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



DETAIL AS
SCALE 2X

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2025-07-27/164

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

A1-11

BA

BLACK ANTI-SKID

REFER TO
SECTION BE-BE

A4-11

(INSTALL NUT ON THIS SIDE)

BB

BC

BD

BE

BB

BC

BD

BE

B7-11

A7-11

B4-11

A4-11

D2750-4
SKIDTUBE

AFTER FINISH,
ALS4-1032-225 INSERT
34 PL

D3794-1
GASKET

D3793-1
WEARSHOE

AN3C5A BOLT
AN960C10L WASHER
34 PL

D3537-1
WEARPAD

D3791-1
WEARPLATE

D3536-25
GASKET

D3535-25
WEARSHOE

D3537-1
WEARPAD

2.0
TYP

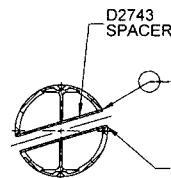
1.78 TO
D2739 WEB

BOND D2739 WEB INTO D2750-4 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

D3488-042
BLADE FITTING

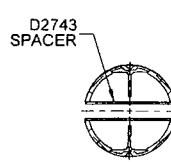
AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 WEARSHOE, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)

D2750-044 350 SKIDTUBE ASSEMBLY, RH



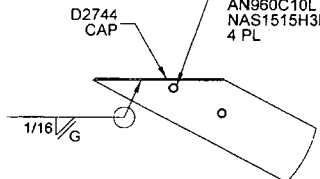
SECTION BB-BB
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484



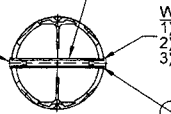
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)



DETAIL BA
SCALE 2X

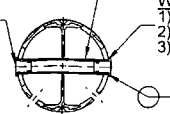
AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL



SECTION BC-BC
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS



SECTION BE-BE
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 298

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barelay Elliott
Job #: 87012
Part #: A350-636-014
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Penetration:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Fusion:	pass[<input checked="" type="checkbox"/>]	fail[]
Cracks:	pass[<input checked="" type="checkbox"/>]	fail[]
Overlap (cold lap)	pass[<input checked="" type="checkbox"/>]	fail[]
Undercut:	pass[<input checked="" type="checkbox"/>]	fail[]
Pin holes:	pass[<input checked="" type="checkbox"/>]	fail[]
Porosity (surface):	pass[<input checked="" type="checkbox"/>]	fail[]
Coloration:	pass[<input checked="" type="checkbox"/>]	fail[]
Burn through:	pass[<input checked="" type="checkbox"/>]	fail[]

Qualifier [Signature] Date of Test Coupon 12.07.23

Welder Barelay Elliott Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld